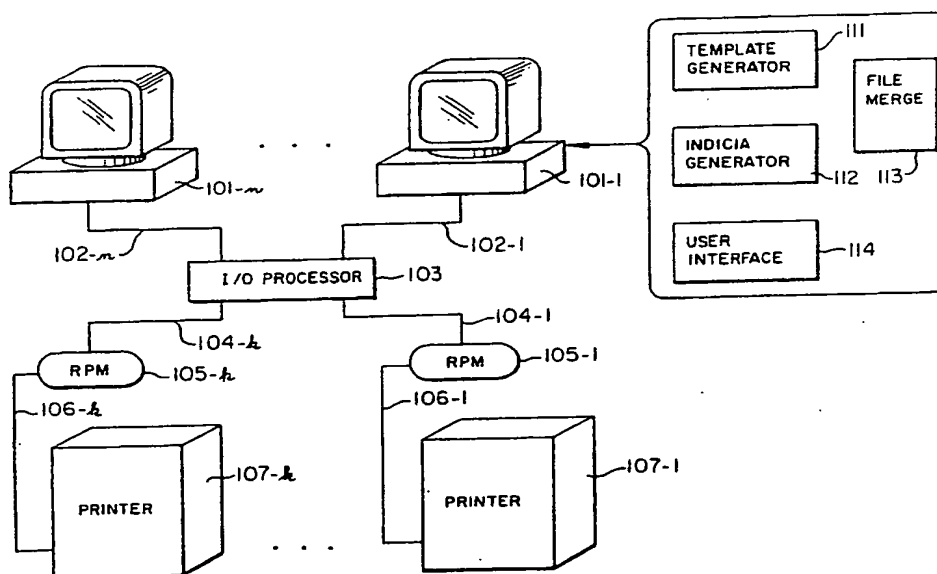




INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification 5 : G06K 1/12, 19/08	A1	(11) International Publication Number: WO 93/1050 (43) International Publication Date: 27 May 1993 (27.05.9)
<p>(21) International Application Number: PCT/US92/10025</p> <p>(22) International Filing Date: 18 November 1992 (18.11.92)</p> <p>(30) Priority data: 07/797,457 22 November 1991 (22.11.91) US</p> <p>(71) Applicant: ENGINEERED DATA PRODUCTS, INC. [US/US]; 2550 West Midway Boulevard, Broomfield, CO 80220 (US).</p> <p>(72) Inventors: BENADE, Daniel, Alan ; 539 Wright Street, Unit 302, Lakewood, CO 80228 (US). JOHNSON, Mack, Evan ; 5682 West 71st Avenue, Arvada, CO 80003 (US).</p> <p>(74) Agent: GRAZIANO, James, M.; Duft, Graziano & Forest, 1790 30th Street, Suite 140, Boulder, CO 80301 (US).</p>		<p>(81) Designated States: AU, CA, JP, European patent (AT, B1 CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, N1 SE).</p> <p>Published <i>With international search report. Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i></p>

(54) Title: LABEL GENERATION APPARATUS



(57) Abstract

The label generation apparatus of this invention enables the user to define a label of various sizes, shapes and characteristics, wherein each label in a series of labels includes unique indicia that individually identify each label according to any predefined sequence. These labels also contain template fields that vary according to the indicia printed thereon or any other predefined ordering. The label generation apparatus includes a template generation capability (111) that enables the user to define a label format having one or more writable indicia fields. These one or more writable indicia fields can be used to provide each label with individual identifying indicia according to any predetermined sequence. The label generation apparatus also includes an indicia generation capability (112) that produces the individual identification according to various characteristics that are specified by the user of this apparatus.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AT	Austria	FR	France	MR	Mauritania
AU	Australia	GA	Gabon	MW	Malawi
BB	Barbados	GB	United Kingdom	NL	Netherlands
BE	Belgium	GN	Guinea	NO	Norway
BF	Burkina Faso	GR	Greece	NZ	New Zealand
BG	Bulgaria	HU	Hungary	PL	Poland
BJ	Benin	IE	Ireland	PT	Portugal
BR	Brazil	IT	Italy	RO	Romania
CA	Canada	JP	Japan	RU	Russian Federation
CF	Central African Republic	KP	Democratic People's Republic of Korea	SD	Sudan
CG	Congo	KR	Republic of Korea	SE	Sweden
CH	Switzerland	KZ	Kazakhstan	SK	Slovak Republic
CI	Côte d'Ivoire	LI	Liechtenstein	SN	Senegal
CM	Cameroon	LK	Sri Lanka	SU	Soviet Union
CS	Czechoslovakia	LU	Luxembourg	TD	Chad
CZ	Czech Republic	MC	Monaco	TG	Togo
DE	Germany	MG	Madagascar	UA	Ukraine
DK	Denmark	ML	Mali	US	United States of America
ES	Spain	MN	Mongolia	VN	Viet Nam
FI	Finland				

LABEL GENERATION APPARATUS

FIELD OF THE INVENTION

This invention relates to the creation of labels and, in particular, to apparatus for generating a series of labels, each of which is individually identified by certain unique indicia and template fields printed thereon.

PROBLEM

It is a problem in the field of label making to inexpensively and efficiently produce labels that are individually identifiable. The art of label making can be classified into two categories. The first category is the generation of a large number of identical labels, such as that found on the vast majority of articles available for retail purchase. The generation of these identical labels requires the creation of a permanent printing master which is repetitively used to generate identical labels in large numbers. The second type of label generation is the creation of a number of printed labels or documents that contain varying indicia printed thereon, where the variation in indicia is according to a well defined and commonly used numbering scheme. An example of this is the printing of checks or bank drafts where the series of checks are printed in sequential order according to a fixed numbering scheme. The generation of these printed documents requires the creation of a permanent or semi-permanent printing master that

-2-

identifies the depositor and the depositor's account number, which information is printed on every check in the series. The varying indicia are the check numbers in the series, and this indicia
5 is obtained by the use of a standard set of printing masters that are used for all similarly numbered checks printed by the bank. Thus, in this application, only a small number of permanent printing masters are required to be able to print
10 all checks for all depositors since the numbering scheme typically runs from 100 to 9,999. In addition, the template or background information on these labels is fixed for all labels, regardless of the indicia printed thereon.

15 No where is there available apparatus for printing items with arbitrarily varying indicia according to any predetermined ordering as well as arbitrarily varying template fields according to any predetermined ordering. To accomplish this
20 would require the generation of custom printing masters for each item that is to be printed. To accomplish this would require tremendous expense and is totally impractical using the printing systems that are presently available in the
25 printing art.

-3-

SOLUTION

The above described problems are solved and a technical advance achieved in the field by the label generation apparatus of this invention. This apparatus enables the user to define a label of various sizes, shapes and characteristics, wherein each label in a series of labels includes both unique indicia that individually identifies each label according to any predefined sequence and template fields that vary according to the indicia printed thereon or any other predefined ordering.

The label generation apparatus includes a template generation capability that enables the user to define a label format having one or more writable indicia fields. These one or more writable indicia fields can be used to provide each label with individual identifying indicia according to any predetermined sequence. The template itself contains one or more variable format fields, wherein the template itself varies as a function of the indicia printed thereon or as a function of any other defined ordering. Thus, the indicia and template fields can both vary from label to label.

The label generation apparatus also includes an indicia generation capability that produces the individual identification according to various characteristics that are specified by the user of this apparatus. The indicia can be alphanumeric characters, bar codes, colors, or any other writable indicia. The user of the label generation apparatus specifies the type of indicia or combinations of the above listed indicia that are to be printed on the individual labels.

The user also specifies the ordering to be used in the generation of this indicia. This ordering can be any arbitrarily selected sequence,

-4-

for example: indicia sequentially numbered according to any numbering system such as binary, decimal, hexi-decimal; indicia ordered according to a series such as odd numbers, even numbers; indicia
5 arbitrarily matched to a data file, such as printing a label for each employee according to their social security number; mixed mode indicia, such as printing one hundred sequentially numbered labels for each department in a corporate
10 organization; or any other conceivable indicia ordering that is desired by the user. Once the scheme of ordering the indicia and the starting and ending indicia are defined by the user, the indicia generation apparatus generates data indicative of
15 the indicia to be used in the series of labels, which data is combined with template definition data to create a set of information that defines each label in the series of individually identified labels.

20 The label generation apparatus uses template generation software that produces template definitions that vary according to various criteria specified by the user of this apparatus. The template variability can be colors, the type of
25 codes imprinted on the label, variable indicia format as a function of label application, or any other variation envisioned by the user. The user of the label generation apparatus specifies the template formats that are to be printed on the
30 individual labels. The user also specifies the ordering to be used in the generation of the templates. This ordering can be any arbitrarily selected application, for example: labels having identical indicia but multiple formats such as
35 printing a label for each employee's personnel file according to their social security number while also printing a different format label for the

-5-

employee's medical file and a third format label for the employee's benefits file; changing the color of the labels printed as a function of a real time clock so that the color fields vary by month and year; or any other conceivable template configurations that are desired by the user. Once the scheme of ordering the templates are defined by the user, the template generation apparatus generates data indicative of all of the templates to be used in the series of labels that are to be printed. This data is then combined with indicia definition data to create a set of information that defines each label in the series of individually identified labels. This data is then used by the label generation apparatus to drive a printing mechanism to transfer the defined individually identified labels onto a label media.

One exemplary embodiment of this label generation apparatus is the use of a computer to generate the definition of both the label template and the label indicia. The computer also combines this data to produce the final information that represents individually identified labels. The computer then drives a printing mechanism such as an electrostatic printer that produces the final labels on the label media. Additional equipment can be used to provide an adhesive backing to the labels so printed to thereby provide the user with individually identified labels in a form and format that is convenient for the particular application.

Thus, this apparatus produces individually identified items without the use of a permanent or semi-permanent printing master. The label generation apparatus generates labels of arbitrary size, shape, and configuration, as defined by the user and media used for the labels. These and

-6-

other advantages of this apparatus are illustrated in the detailed description below.

-7-

BRIEF DESCRIPTION OF THE DRAWING

Figure 1 illustrates in block diagram form the architecture of the label generation apparatus;

5 Figure 2 illustrates in flow diagram form the overall functional structure of the label generation apparatus in flow diagram form;

Figure 3 illustrates a typical output format for a series of ordered labels;

10 Figures 4 through 8 illustrate typical label configurations that can be generated using this apparatus;

Figure 9 is a cross section view of a portion of a label;

15 Figure 10 is a cross section view of a portion of a scored label stock;

Figure 11 is a schematic view of apparatus used to produce rolled strips of label stock;

Figure 12 illustrates a cross section view of a portion of stripped, slit label stock;

20 Figure 13 illustrates a typical user data file;

Figure 14 illustrates in flow diagram form the operational steps taken by this apparatus to produce labels;

25 Figure 15 illustrates the user display produced by the system to enable a user to define a label template; and

Figure 16 illustrates the user display, including a defined label template.

-8-

DETAILED DESCRIPTION

The label generation apparatus of this invention enables the user to define a label of various sizes, shapes and characteristics, wherein
5 each label in a series of labels includes unique indicia that individually identify each label according to any predefined sequence and these labels also contain template fields that vary according to the indicia printed thereon or any
10 other predefined ordering.

The label generation apparatus includes a template generation capability that enables the user to define a label format having one or more writable indicia fields. These one or more
15 writable indicia fields can be used to provide each label with individual identifying indicia according to any predetermined sequence. The template itself contains one or more variable format fields, wherein the template itself varies as a function of
20 the indicia printed thereon or as a function of any other defined ordering. Thus, the indicia and template fields can both vary from label to label.

The label generation apparatus also includes an indicia generation capability that produces the
25 individual identification according to various characteristics that are specified by the user of this apparatus. The indicia can be alphanumeric characters, bar codes, colors, or any other writable indicia. The user of the label generation
30 apparatus specifies the type of indicia or combinations of the above listed indicia that are to be printed on the individual labels.

The user also specifies the ordering to be used in the generation of this indicia. This
35 ordering can be any arbitrarily selected sequence, for example: indicia sequentially numbered according to any numbering system such as binary,

-9-

decimal, hexi-decimal; indicia ordered according to a series such as odd numbers, even numbers; indicia arbitrarily matched to a data file, such as printing a label for each employee according to their social security number; mixed mode indicia, such as printing one hundred sequentially numbered labels for each department in a corporate organization; or any other conceivable indicia ordering that is desired by the user. Once the scheme of ordering the indicia and the starting and ending indicia are defined by the user, the indicia generation apparatus generates data indicative of the indicia to be used in the series of labels which data is combined with template definition data to create a set of information that defines each label in the series of individually identified labels.

The label generation apparatus uses template generation software that produces template definitions that vary according to various criteria specified by the user of this apparatus. The template variability can be colors, the type of codes imprinted on the label, variable indicia format as a function of label application, or any other variation envisioned by the user. The user of the label generation apparatus specifies the template formats that are to be printed on the individual labels. The user also specifies the ordering to be used in the generation of the templates. This ordering can be any arbitrarily selected application, for example: labels having identical indicia but multiple formats such as printing a label for each employee's personnel file according to their social security number while also printing a different format label for the employee's medical file and a third format label for the employee's benefits file; changing the

-10-

color of the labels printed as a function of a real time clock so that the color fields vary by month and year; or any other conceivable template configurations that are desired by the user. Once the scheme of ordering the templates are defined by the user, the template generation apparatus generates data indicative of all of the templates to be used in the series of labels that are to be printed. This data is then combined with indicia definition data to create a set of information that defines each label in the series of individually identified labels. This data is then used by the label generation apparatus to drive a printing mechanism to transfer the defined individually identified labels onto a label media.

System Architecture

Figure 1 illustrates the architecture of the preferred embodiment of the label generation apparatus in block diagram form. This label generation apparatus includes one or more processors (101-1 to 101-n), each of which is a small computer such as a commercially available personal computer. The plurality of processors (101-1 through 101-n) are each interconnected via an associated bus (102-1 to 102-n) to one or more input/output processors 103. The function of the input/output processor 103 is to act as a buffer to receive and temporarily store data files that are output by the one or more processors 101-1 to 101-n. These data files are output by input/output processor 103 over one of the one or more output bus leads 104-1 to 104-k. These output bus leads 104-1 to 104-k interconnect input/output processor 103 with one or more printers 107-1 to 107-k. Each printer illustrated in Figure 1 is equipped with a raster processing machine 105-1 to 105-k that is

-11-

interposed between the associated printer 107-1 to 107-k and the corresponding output bus lead 104-1 to 104-k. The function of the raster processing machine is to convert the data file that is down
5 loaded from one of processors 101-1 to 101-n into a form and format that is usable by the associated printer 107-1 to 107-k. The raster processing machines 105-1 to 105-k can be stand alone units as illustrated in Figure 1 or can be incorporated into
10 the associated printer 107-1 to 107-k. The stand alone units are described herein for illustration purposes.

For example, processor 101-1 generates an output data file to control the operation of
15 printer 107-k. Processor 101-1 transmits this output data file via bus 102-1 to input/output processor 103 where it is temporarily stored in a buffer. When printer 107-k is available to print the label definition data that is stored in this
20 data file, input/output processor 103 transmits the data file in object code form via output data bus 104-k to raster processing machine 105-k that is associated with printer 107-k. Raster processing machine 105-k converts the object file into ASCII
25 raster data that is used to drive the print mechanism in printer 107-k. The ASCII raster data is output a byte at a time by raster processing machine 105-k via control leads 106-k to printer 107-k to cause the printer 107-k to print the label
30 definition data that is contained in the original data file that was transmitted by processor 101-1.

In this preferred embodiment, the label generation apparatus is illustrated as including one or more processors 101-1 to 101-n and one or
35 more printers 107-1 to 107-k. An alternative implementation is the use of a single processor and multiple printers or multiple processors and a

-12-

single printer. Similarly, a single input/output processor 103 is illustrated in Figure 1 while a plurality of these input/output processors may be used in a particular implementation. The selection of the numbers of the devices illustrated in Figure 1 and their precise interconnection is a function largely of the capability of the devices selected. Thus, a powerful processor 101-1 can be used to drive a plurality of printers if the processor 101-1 can generate data files at a rate faster than a single printer can print the files. Therefore, depending on the throughput required of the label generation apparatus illustrated in Figure 1, n processors can be used to drive k printers which are interconnected through one or more input/output processors 103. In some applications, input/output processor 103 can be dispensed with and a direct connection implemented between the one or more processors and the one or more printers. These are all implementation details that should not be construed to limit in any way the concept of the label generation apparatus described and claimed herein.

Printer

The term printer as used herein describes any of the various commercially available computer-driven systems that produce human readable and/or machine readable imprints on media. These systems include electrostatic plotters, laser printers, dot matrix printers, thermal printers, magnetic strip writers, magnetic ink character recognition (MICR) printers, and pen plotters.

One example of a state of the art printer that produces human readable output is the electrostatic plotter, such as the Versatec™ VS3000 plotter manufactured by Versatec, Inc. of Santa Clara,

-13-

California or the ColorWriter 400 plotter manufactured by Synergy Computer Graphics Corporation, of Sunnyvale, California. The electrostatic plotter uses four toner colors (black, cyan, magenta, yellow) to produce 2048 output colors. The plotter produces 400 pixels per inch onto the print media which typically is a 24", 36" or 44" by 200 foot roll of mylar. Other print media can be used, such as paper or other transparent materials. In addition, a sandwich or composite label can be produced, with the label printed on paper and overlaid with a protective transparent layer. The plotter includes a raster processing machine either as an integral part of the plotter or a separate stand-alone unit. The raster processing machine receives print data from the processor generating the label data via an RS232C serial interface. The raster processing machine accepts industry-standard data formats and rasterizes this data into printer control signals.

The plotter uses either a single or a multipass color plotting technique to ensure data registration accuracy. The multipass technique marks the media to end of plot in the first pass to assure proper registration. The media is then automatically rewound to plot starting position. Four passes, each writing one color from one of the four toner stations, overlay the four primary colors - black, cyan, magenta, and yellow. The plotter includes automatic precision tracking apparatus to maintain registration to better than one-half dot. This registration accuracy enables the user to define 2048 colors.

A printer such as the electrostatic plotter can produce colors, alphanumeric characters, bar codes that can be read by a human or a machine vision system. Thus, the electrostatic plotter can

-14-

produce a wide spectrum of label formats and, for that reason, is described in the preferred embodiment. Other printer mechanisms can be used to produce magnetically readable indicia such as MICR printers, but are not described in detail herein.

Control Software - Template Generator

The remaining elements on Figure 1 consist of the control routines 111-114 that are loaded in each of processors 101-1 to 101-n. These control routines are used to construct the database or data file that is used to drive the printer to produce the labels desired by the user. These control routines include user interface 114 which is a routine to interface the label generation apparatus in user friendly fashion with the user at the keyboard and display of one of the processors, for example processor 101-1. This user interface 114 can be menu driven software that permits the user to select the label format and define the label content as well as the number of labels to be produced by label generation apparatus. The data obtained through user interface 114 drives template generator 111 and indicia generator 112.

Template generator 111 produces a definition of both the replicated and variable parts of the label. The replicated part of the label may include printed delimiters that are used to define various writable indicia fields. The indicia field delimiters may also be simply predefined areas on the label that are not separated by any printed delimiters. In addition, template generator 111 produces the standard invariant textual or visual information that is part of the standard label design. Template generator 111 can also produce registration marks (r on Figure 3) that are used to indicate bench mark positions on the label media

-15-

that is printed with one or more of the labels. The registration marks become important when entire sheets of labels are produced by the printer and these sheets of labels must be cut into individual
5 labels. The registration marks provide alignment points which can be used by an automatic cutting device to accurately cut the labels according to a predetermined pattern. Another function of
10 template generator 111 is to generate stop and start characters when the indicia to be printed on the label comprise a bar code in whole or in part. A typical bar code includes start and stop characters such as a dollar sign or an asterisk at the beginning and end of the bar code field. Since
15 these start and stop characters are immutable from label to label, template generator 111 can produce these characters as part of the overall label template.

Template generator 111 can consist of the
20 above described label template or can also include a sheet template (Figure 3) that generates a plurality of the label templates to be printed on an entire sheet of label media by the printer. An example of such an arrangement is the printing of
25 a sheet of labels consisting of a matrix of N by M labels arranged in linear fashion. Thus, the sheet template can replicate the individual label template into a pattern of N by M label templates and adds the appropriate registration marks r on to
30 the sheet of labels that are to be printed. The definition provided by the user through user interface 114 indicates the configuration of labels that are to be printed by the printer.

A plurality of sheets of labels wherein each
35 sheet consists of n by m labels can be designated by the user. Figure 3 illustrates one sheet definition arrangement. A master block (ex-M_{1,1}) is

-16-

defined as a matrix of $m * n$ labels arranged in m rows of n labels each. The master block $M_{1,1}$ is itself replicated as the element in an $l * k$ matrix. Thus, by this process, an array of $N * M$ labels is defined where $N = m * l$ and $M = n * k$. Furthermore, this sheet definition can be replicated sequentially any number of times along the length of the label media.

Template generator 111 is typically a library of standard label designs or formats that can be selected by the user. These label designs are produced, for example, by the use of a graphics software package that is included in template generator 111 on-line on one of processors 101-1 to 101-n or off-line on another processor (not shown) as a stand-alone unit. Such graphics software packages are well known and include the following commercially available packages: ISSCO, CATIA, CADRAM, UNIRAS, Precision Visuals, AutoCAD, SAS, D-Pict, PATRAN, Graphics Software Systems/CGI. The user generates the label template, including delimiters, textual and visual information as well as printing registration marks, using a graphics software package and stores this information in template generator 111 as a library routine that can be accessed for label generation purposes.

Template generator 111 also defines and generates the variable template fields. The user, via user interface 114, defines the type and character of the variable format template fields to be produced, the ordering of the variable template fields and the indicia field correspondence among the variable template fields. Thus, the labels produced by the label generation apparatus can each be uniquely defined by the individual indicia contained thereon; or can be aggregated into subsets, where each subset consists of a plurality

-17-

of labels, each label in a subset having at least one different template field but identical indicia such that each label in the subset contains identical indicia that are printed in varying
5 format or configuration; or can be aggregated into subsets, where each subset consists of a plurality of labels, each label in a subset having at least one different template field and varying indicia such that each label in the subset contains some
10 different indicia and some of the indicia are printed in varying format or configuration.

Control Software - Indicia Generator

Indicia generator 112 defines and generates the indicia that are produced for the writable
15 indicia fields in the labels defined by template generator 111. The user, via user interface 114, defines the type and character of the indicia to be produced, the ordering of the indicia from label to label and the starting and stopping points of the
20 indicia. Thus, the labels produced by the label generation apparatus can be sequentially numbered, ordered according to a predefined series or matched to a database input by the user, and containing an arbitrary indicia listing. Indicia generator 112
25 produces the sequence of indicia via the use of program control instructions that define the ordered sequence selected by the user. The program control instructions typically are mathematical routines that define the sequence of indicia. As
30 with the template definitions, the indicia sequences can be a library of standard software routines that are user-selectable or can be a user programmed sequence. Indicia generator 112 responds to the selection of the desired ordering
35 as well as data input by the user through user interface 114 defining the form of the indicia to

-18-

be used. The indicia consists of any sort of identification that can be printed on the label. This identification can be bar codes, alphanumeric codes, magnetic strips or color codes.

5 Once the indicia form is defined, the user through user interface 114 defines the format of the indicia. The format can be the order that the indicia are printed in the writable indicia fields, the specific combination of indicia such as
10 selecting either a single set of indicia or duplicate or redundant indicia. An example of redundant indicia is the case where a bar code is printed on the label, and adjacent to the bar code is written the numeric equivalent of the bar code
15 characters. An alternative is the use of color coded indicia that are written into each of the writable indicia fields on top of which is written the corresponding alphanumeric character that matches the defined color coding. Similar
20 arrangements can be used and are discussed below for MICR encoding, alphanumerics, color coding and bar coding. The user can also define the starting value of the indicia to be printed in the first label in the series of labels that are printed.

25 Once the various parameters defining the indicia are input to indicia generator 112 via user interface 114, indicia generator 112 generates the series of indicia that are used to individually identify all of the labels in the series of labels
30 that are to be printed. Indicia generator 112 generates the first set of indicia based on the data input by the user through user interface 114 and then calculates the next indicia values based on the defined ordering provided by the user. The
35 indicia values are calculated on a label by label basis and stored in a data file typically on a sheet by sheet basis although this data can be

-19-

stored on a label by label basis. Once the data file defining the various indicia values is completed, the indicia values are converted into control signals corresponding to the form and format as well as the content of the indicia. File merge routine 113 combines the template generated by template generator 111 with the indicia information generated by indicia generator 112 into an object file which is stored in processor 101-1. This object file contains all of the data necessary to define all of the labels in the series of individually identified labels that are to be printed by the label generation apparatus.

The object file stored in processor 101-1 is downloaded over data link 102-1 to input/output processor 103 which is a slave buffer processor used to store the object files before they are printed by the designated printing device. Alternatively, processor 101-1 downloads the generated data over data link 102-1 to input/output processor 103 as it is produced rather than storing an entire file. The labels can be produced by printers 107-1 to 107-k as the label data is produced. Input/output processor 103 is a computer such as an 80286 based processor board which functions under the control of the one or more processors 101-1 to 101-n to transmit the object files to the one or more printers 107-1 to 107-k.

Input/output processor 103 stores object files to be output on the various ones of printers 107-1 to 107-k. The apparatus used to implement the printers 107-1 to 107-k are any secondary device that can be controlled by a computer. These devices include electrostatic plotters, laser printers, dot matrix printers, thermal printers, MICR printers, magnetic strip writers and any other such devices.

-20-

Label Generation Control Software

Each label generally consists of two sections:
a human readable section, a machine readable
section. The human readable section includes
5 pictorial and written information that identify the
item labeled as well as its source or origin. The
pictorial information includes fanciful drawings to
make the label more attractive to the user and
colored background areas to simplify the
10 identification of the object to which the label is
affixed. The textural information provided on the
label in human readable form is generally in the
form of alphanumeric characters that identify the
item that is labeled.

15 The machine readable section of the label
generally consists of some indicia that can be read
by a machine for pricing or object identification
purposes. In the field of machine readable codes,
the bar code is the most widely used and recognized
20 form of machine readable codes and is utilized on
numerous commercial articles. One bar code in
particular, the universal product code (UPC), has
gained widespread acceptance. The universal
product code numbering system is described in the
25 "UPC symbol specification" published by the Uniform
Product Code Council, Inc., Dayton, Ohio, and is
designed for use primarily with ten digit codes
that can be expanded to longer codes. The standard
symbol in this bar code is in the form of a series
30 of parallel light and dark bars of different widths
and a corresponding OCR-A or B numeric font
equivalent which is referred to as the "bar code
symbol". In a typical ten digit universal product
code symbol, the symbol consists of a series of
35 thirty (30) dark and twenty-nine (29) light
parallel bars with a light margin on each side,
each character or digit of the code being

-21-

represented by two dark bars and two light spaces. The overall shape of the bar code is rectangular in nature, with each character being independent. The character is typically made up of seven data
5 elements or modules which may be light or dark and the bar may be constructed from one to four dark modules. The universal product code also includes two characters beyond the ten needed to encode the universal product code. One character is a modulo
10 check character and is embedded in the rightmost portion of the symbol to ensure a high level of reading for reliability. The second character is embedded in the leftmost position of the universal product code and shows which number system a
15 particular symbol encodes.

The symbol size in the universal product code is infinitely variable in order to accommodate the ranges and quality achievable by various printing processes. That is, the size of the symbol can be
20 uniformly magnified or reduced from a nominal without significantly affecting the degree to which it can be scanned. The universal product code symbol is also capable of preventing tampering. Unauthorized editions of lines on the preprinted
25 symbol is readily detectable by conventional scanning devices. Similarly, poor printing will not result in the scanning devices reading a wrong number since the symbol has multiple error detecting features which allows scanner designers
30 to build equipment to automatically detect and reject a very poorly printed symbol or one that has been tampered with. Such symbols also incorporate and present the code number in human readable form as the bar code symbol.

35 Many other forms of bar codes exist. For example, the code 39 or "3 of 9" bar code and the interweaved 2 of 5 code have achieved equal

-22-

widespread application. Such codes, like the universal product code, consist of a plurality of light and dark parallel bars variously arranged to encode information with features to prevent tampering and account for poorly printed symbols. The 3 of 9 bar code also is capable of encoding alphabetical characters as well as numerical characters.

Another form of machine readable code is alphanumeric characters printed in an OCR format. These alphanumeric characters can be scanned by a vision system which translates any printed alphanumeric characters into data that is stored in a computer system. Another form of machine readable indicia is magnetic strips which are a pattern of magnetized and unmagnetized stripes that can be read by a magnetic sensor. The magnetic stripe reader is similar to the vision system bar code reader in function. Yet another form of machine readable code is the magnetic ink character recognition (MICR) system which uses an ink having a magnetic material therein to imprint machine readable magnetic indicia on a document.

Label Formats

Figures 4-8 illustrate various label formats wherein combinations of human and machine readable indicia are printed on a label. Figure 4 illustrates a typical magnetic tape cartridge label 400 that is well known in the art. This label 400 consists of a rectangular shaped label contained a plurality of indicia fields 411-416 each of which is coded with a background color 431-436 and a alphanumeric character 421-426 printed therein. The color 431-436 and alphanumeric character 421-426 indicia uniquely identify each magnetic tape cartridge. Each indicia field 411-416 can be

-23-

separated from an adjacent indica field by the use of a delimiter or printing trap 441 that consists of a solid line but the use of such a printed delimiter is not required.

5 Another form of rectangular label is illustrated in Figure 5. This label contains both human readable and machine readable indicia. A first vertical column 401 imprinted on label 400 is divided into a series of vertically aligned, rectangular segments 411-416, each of which are
10 separated from a contiguous other by a printing trap consisting of a solid line 441. The rectangular segments are also separated from a second vertically aligned column 402 adjacent to and coextensive with the first vertical column 401
15 by another printing trap 442 consisting of a solid line. One character 421-426 of machine readable and human readable code (such as an optical character recognition code) is located within each rectangular segment 411-416 in the first column 401
20 thereby forming a message in a first code. The second vertical column 402 contains a single machine readable code such as an UPC bar code which consists of a message in the second code which is
25 identical to the message formed in the first vertical column 401. Moreover, the backgrounds 431-436 of each of the rectangular segments 411-416 contained within the first vertical column 401 is suitably color coded to correspond to the
30 respective data characters 421-426 contained therein thereby providing a message in a third code which is identical to the above described messages of the first and second codes. For example, the numeral "1" corresponds to the color blue, "2"
35 corresponds to gray, "3" corresponds to green, "4" corresponds to orange, "5" corresponds to brown and, "0" corresponds to red. The bar code encoded

-24-

on this label includes start and stop characters such "*" or "\$".

Figure 6 illustrates a typical bar code label that contains a rectangular shaped field of indicia containing a bar code 601 and the corresponding OCR characters 602. The bar code 601 and associated OCR characters 602 provide a unique human readable and machine readable identification of the object to which the label is affixed. No printed delimiters are used in this label to separate the bar code 601 from the OCR characters 602. In addition, no textual or visual information or background printing is illustrated in this label.

Figure 7 illustrates another label application wherein a plurality of indicia fields are provided and these indicia fields are not only machine readable and human readable but the human readable characters are in a plurality of languages. The label illustrated in Figure 7 contains a bar code 701, a corresponding set of OCR characters 702 and set of indicia in the arabic language 703. Thus, either a plurality of different indicia or the same indicia reproduced in a plurality of forms are writable on the label.

Figure 8 illustrates an oval shaped label that contains a rectangular shaped field of indicia containing a bar code 801 and the corresponding OCR characters 802. The oval shaped label contains both fanciful 805 and information conveying areas 803, 804 that identify the source of the identified object to the user. In addition, the bar code 801 and OCR characters 802 provide a unique human and machine readable identification of the object to which the label is affixed. A typical application of such a label would be a standard commercially available product that is identified by the bar code 801 and OCR characters 802 for the purpose of

-25-

scanning for inventory control to identify the quantity of the labeled objects that are stored in stock.

Label Generation Process

5 The difficulty with the existing label generation systems is that these systems can either generate a vast quantity of identical labels or a number of differently identified labels according to a well defined and commonly used numbering
10 scheme. None of the existing systems can generate arbitrarily varying indicia according to any predetermining ordering for printing on labels to individually identify each label without using permanent or semi-permanent printing masters. The
15 label generation apparatus of the present invention enables a user to define a label of various sizes, shapes and characteristics, wherein each label in a series of labels includes unique indicia that individually identify each label according to any
20 predefined sequence in both human readable and machine readable form without using printing masters.

 The label generation apparatus includes the control structure illustrated in Figures 2 and 3 in
25 flow diagram form. The control structure of Figures 2 and 3 consists of a plurality of software routines resident on processor 101-1 to 101-n. In order to better understand the operation of the control structure illustrated in Figures 2 and 3,
30 the generation of a plurality of the label illustrated in Figure 5 is described. A sheet of label media is used to produce a matrix of n times m of the labels of Figure 5. This matrix arrangement is illustrated in Figure 3 wherein one
35 sheet of the label media containing N times M labels are illustrated. The process of label

-26-

generation begins at step 200 on Figure 2. Processor 101-1 prompts the user at the associated keyboard at step 201 to enter initializing information to identify the label format, i.e. -
5 the label of Figure 5, as well as the initial value used for the indicia written on this label. The user at this step also inputs the final label value or the quantity of labels that are to be printed. It is assumed that there is a standard
10 correspondence between the alphanumeric characters printed on the label and the color background printed in the indicia fields. If the user wishes to vary this standard correspondence, data can be entered at step 201 to redefine the correspondence
15 in processor 101-1. Assume for the purpose of this description that the standard format and color/numeric correspondence is desired. At step 202, the user defines the starting x and y position coordinates of the label generation on the sheet of
20 label media.

In response to the data entered by the user at steps 201 and 202, processor 101-1 retrieves the initial label value entered by the user and sets the label count variables equal to 1. Processing
25 advances to step 204 where the label template is retrieved from the memory of processor 101-1. This label template consists of all of the standard invariant non-indicia printing on the label. The label template includes the vertical and horizontal
30 print traps that function as delimiters to identify each indicia field on the label. The label template also includes the start and stop characters in the bar code. Any other invariant printing on the label is also drawn at this point.
35 For the purpose of this description, the term "draw" indicates the generation of the control information required to activate one of printers

-27-

107-1 to 107-k to actually print the identified information on the label media. In the multi processing environment illustrated in Figure 1, the entire sheet of label media is typically drawn at the same time rather than on a label by label basis as processor 101-1 generates the control signals. Thus, the control process illustrated in Figures 2 and 3 result in the generation of a data file that consists of all of the control information required to activate one of printers 107-1 to 107-k to produce an entire sheet or collection of sheets of labels. Thus, at step 204 when processor 101-1 "draws" the label template for the first label in the series of labels, processor 101-1 stores the data indicative of the template in a data file associated with this print job.

File Merge

At step 205, processor 101-1 retrieves the present value of the label indicia which, in this case, is the initial label value input by the user at step 201. At step 206, processor 101-1 converts the present label value into a set of optical character recognition (OCR) characters. These characters are drawn at step 207 in the appropriate indicia fields in the label template. At step 208, processor 101-1 obtains the correspondence between the generated OCR characters and the background colors required for each of the indicia fields in which these OCR characters are printed. At step 209, processor 101-1 generates the control signals to activate the printer to draw the colored area fills for each of the indicia fields in the label. At step 210, processor 101-1 retrieves the bar code values corresponding to the generated OCR characters. At step 211 these bar codes are drawn in appropriate indicia fields in the label

-28-

template. This step completes the generation of a single label including the label template, the OCR characters, color background indicia and bar codes.

Label Sequencing

5 Once the label is completed, processing advances to step 212 where processor 101-1 increments the label count, the horizontal position variable and the value of the label indicia. The label indicia can be numbered according to any
10 predetermined ordering that is required by the user. This can be a sequential numbering, an ordered series, or correspondence to any input data file provided by the user. Thus, label count and label indicia value record are maintained
15 separately by processor 101-1 since the label numbering may not be sequential and may not match the label count. Processor 101-1 must increment the label count at step 212 and generate the next label indicia value according to whatever
20 predetermined ordering has been identified by the user. At step 213, processor 101-1 increments the horizontal position variable. At step 214, processor 101-1 compares the horizontal position variable with the defined maximum number of
25 horizontal print positions for the particular sheet of label media to be printed. Thus, in the example of Figure 8, a matrix of N times M labels are to be printed on the sheet of label media. For the purpose of illustration, the number of labels on a
30 master block $M_{1,1}$ of label media is five rows of twenty columns. Thus, at steps 213 and 214, the horizontal position count is incremented and compared with the delimiter of twenty to determine whether the entire row of twenty labels in the
35 first block has been printed. If the entire row of twenty labels has not been printed, at step 214

-29-

processor 101-1 returns control to step 204 where another label in the sequence of labels is generated. The processing of steps 204 to 214 continues until an entire row of twenty labels has been printed. At this point, processing advances to step 215 where the vertical position count is incremented and at step 216 compared with the maximum value (which for this case is five). Thus, steps 213 and 214 generate a row of twenty labels while steps 215 and 216 generate five rows of twenty labels.

Once processing of this master block M_1^1 of 100 labels in a 20x5 matrix has been completed, processing advances to step 217 where the vertical position variable is reset to 1 and the horizontal block position is incremented. At step 218, the horizontal block position is compared with the maximum value which in this case is 2. Similarly, steps 219 and 220 reset the horizontal block position to 1, increment the vertical block position and compare it with a maximum value which in this case is 5. Thus, steps 213-220 generate a matrix consisting of a master block of 100 labels in a 20 wide by 5 high configuration which master block is replicated twice horizontally and five times vertically on a sheet of label media to produce a series of 1,000 labels. This series can be of arbitrary length but for the purpose of illustration is indicated here to be a length of 1,000 which is a typical number that would be used. Once the entire 1,000 labels are printed using the control routine illustrated in Figures 2 and 3, processing advances to step 221 where the generation process is completed.

-30-

File Transmission

At this point, the entire data file consisting of the template and the label indicia information for all 1,000 labels is stored in processor 101-1. Since the series of labels is ready for printing, processor 101-1 transmits this data file to input/output processor 103 via bus 102-1 where the data file is stored until one of printers 107-1 - 107-k is available to print this data file. Assume for the purpose of discussion that printer 107-1 is available to print the data file. Input/output processor 103 transmits the data file over output bus 104-1 to raster processing machine 105-1 associated with printer 107-1. Raster processing machine 105-1 converts the data file that is downloaded from processor 101-1 via input/output processor 103 into a form and format that is usable by printer 107-1. Raster processing machine 105-1 converts the object file form of the data file into ASCII raster data that is used to drive the print mechanism in printer 107-1. The type of control information that is provided in the object file are control signals indicative of which pen in the plotter is to produce a particular segment of the label, pen up and pen down commands, and data indicative of the starting position length and direction of each line or character printed on the label.

Label Media

The labels produced by the label generation apparatus (for example - Figure 4) comprise an elongated rectangular shape base sheet member 102 (see Figure 9) made of clear plastic material, such as Mylar, having a flat, smooth, glossy front surface 104 and a flat back surface 106 which has been chemically treated to enable electrostatic ink

-31-

printing thereon as generally indicated by ink layer zone 108. The OCR alphanumeric characters 421-426 and corresponding colors 431-436 are reverse-printed with ink on the back surface 106 thereof in the printed ink zone 108 so as to be viewable in proper orientation through the front surface 104 thereof. Label graphics as they appear when viewed through front surface 104 are shown in Figure 4, which is a front view of a back-printed plastic sheet. A layer of opaque adhesive material 110, Figure 9, is fixedly adhered to the entire printed back surface 106 of the sheet member 102 in overlaying, covering relationship with the printed characters 421-426, and colors 431-436, thereon. Thus, unlinked portions (e.g. all of the spaces between the dark bars of the bar code alphanumeric characters in the second column 402 of Figure 5) of the base sheet member material 102 appear to be the color of the opaque adhesive material 110 when viewed through the front surface 104 of base sheet member 102. The ink zone may have a single layer of ink, e.g. the black color bar code lines and the black color zone separating lines or multiple layers of ink where the black color alphanumeric indicia have a different color background overlay. A removable sheet 114 of backing material is removably adhered to the layer of opaque adhesive material 110, the backing material 114 being constructed of a substance such as treated paper which forms a weaker bond with the adhesive layer 110 than the plastic base member 102. Thus, the backing sheet is readily removable from the label prior to application of the label to a surface without removal of the adhesive layer 110 from the plastic layer 102.

Label Manufacturing Method and Apparatus

The present invention also comprises a method and apparatus for producing labels of the type described above. The apparatus for forming labels, in general, comprises an electrostatic printer 107-1, Figure 1, and a laminator 179, Figure 11. A continuous web of clear plastic sheet material 132 is provided in a selected width, e.g. 24 inches. The clear plastic web 132 is preferably a relatively stiff, high abrasion-resistant plastic material such as polyethylene terephthalate resin, which has been treated for electrostatic ink printing and is available commercially from the DuPont Company under the product name "Mylar". The plastic web preferably has a thickness of between 3 mils and 5 mils, and most preferably 4 mils.

The clear plastic web 132 is supplied to a conventional electrostatic printer 107-1. The electrostatic printer 107-1 is programmed to print reverse-image graphics and background colors on the web 128 corresponding to the graphics and colors of the label described above with reference to Figure 1. In the preferred embodiment, the zone separation lines and alphanumeric and bar code images are printed first in black ink onto the back side of the plastic sheet material. Then the various background colors are selectively printed in the selected color inks onto the back side of the plastic sheet material over and around the alphanumeric ink images. The adhesive material preferably has a white color to provide maximum contrast with the black and other color ink. As illustrated in Figure 11, a laminating apparatus for forming rolled strip label stock may comprise an adhesive web unwind spool 180 which provides a continuous adhesive web 172. In an embodiment of the invention in which the adhesive web 172 is

-33-

provided with two backing layers 176, 178, a second backing layer stripping assembly 182 is provided which strips off and collects second backing layer 178 on a backing layer collection spool 184. The adhesive web 172 positioned downstream of the backing layer stripping assembly 182 thus has an exposed adhesive layer 174 on the upper portion thereof and a backing layer 176 on the lower portion thereof. If a single-backed adhesive web 172 is used, the need for the second backing layer stripping assembly 182 is, of course, obviated. The apparatus also includes a back-printed plastic web supply means such as unwind spool 188. The printed back surface 171 of the plastic web (which corresponds to surface 106 of a subsequently-formed label) is positioned upwardly and unprinted surface 104 is positioned downwardly in the arrangement illustrated in Figure 11. The adhesive web 172 and the back-printed plastic web 132 are both drawn into a laminating nip 190 formed by laminating rolls 192, 194 with the plastic web printed surface 171 being placed in contact with the exposed adhesive layer 174. The two webs are urged into compressive contact by the rolls to form a composite web 196, as illustrated generally in Figure 9 prior to the occurrence of cut 200 (Figure 10).

The composite web 196 initially passes through a scoring station 198 in which scoring blades 200, shown schematically in Figure 10, provide a plurality of cuts 202. The knife 200 illustrated in Figure 10 is shown raised above cut 202, but it will, of course, be understood that, during an actual cutting operation, the knife would be positioned within the area indicated by the cut 202. The cut 202 extends through the clear plastic layer 102 and adhesive layer 110, terminating at

-34-

the interface 111 between the adhesive layer 110 and backing layer 114. A scored web 210, as shown in Figure 10 including the areas shown in solid lines and in phantom lines, thus emerges from scoring station 198. A scrap web stripping means which may include a scrap windup spool 212 and an idler roll 213 is provided for stripping a continuous scrap web 214 from the scored web 210 to provide a stripped label stock web 216, as shown in Figure 10 in solid lines only. The continuous scrap web 214, Figure 10 in phantom, comprises the portions of plastic layer 102 and adhesive layer 100 other than the portions thereof associated with label graphics and none of the backing layer 114. The stripped label stock web 216 includes all of the continuous backing layer 114, the portion of plastic layer 102 which was back-printed with label graphics, and the portion of adhesive layer 110 directly underlying the portion of layer 102 with graphics printed thereon. The stripped label stock web 216 thus formed passes through a slitting station 218 whereat a plurality of slitting knives 220, Figure 12, longitudinally slit the stripped label stock web 216 to form a slit label stock web 222 comprising a plurality of longitudinally-extending strips 224, 226, 228, 230, 232, etc., defined by cuts 217, which are each one label wide. The slit label stock web 222 is collected on a slit web windup spool 240, Figure 11, and thus provides a plurality of rolls of label strip stock 224, 226, etc.

Alternatively, the structure of Figure 9 can be modified to substitute a paper printing web 108 to which the printing is applied in place of the ink layer 108 applied to the back side 106 of the clear plastic web 102.

-35-

Variable Template Generation

Within the template generator 111 described above, is included control software to enable a user to create label formats and to produce labels with variable templates. Thus, the series of labels can include subsets of labels where each subset consists of a plurality of labels, each label in a subset having at least one different template field but identical indicia, such that each label in the subset contains identical indicia that are printed in varying format or configuration; or can be aggregated into subsets, where each subset consists of a plurality of labels, each label in a subset having at least one different template field and varying indicia such that each label in the subset contains different indicia and some of the indicia are printed in varying format or configuration.

One example of such capability is illustrated in Figures 13 and 14 wherein Figure 13 represents a database of employee information and Figure 14 is a typical variable template label generation program in flow diagram form. The database includes typical relevant employee data and whenever an employee is added to the payroll, a plurality of employee labels need be produced: payroll file, department file, medical file. The label for each of these files can be customized to match the specific needs of that application and the labels can include indicia that are automatically produced by indicia generator 112 and indicia that are input via the database illustrated in Figure 13. The individual label templates are produced by a user and stored in memory in template generator 111 for access by the label generation programs such as that illustrated in Figure 14.

Label Generator Application Functional Flow

The Label Generator Application is a "point and click" application which allows a user to design, build, and generate a label from the available tools. The user can take a design concept, build a block-wire diagram of the label and generate a basic label configuration. Since every label design is different, there is no set way to build a label. However, there are certain guidelines and procedures involved in the label generation process which are outlined here.

The Label Generator Application (LGA) is actually a two phase process. The first phase is a graphical design process which generates a label configuration file (LCF). The second phase of the application takes the label configuration file and processes the information to generate an actual hardcopy label. All of the label generator application functionality is controlled from the applications main screen illustrated in Figure 15. This main screen is split into four general areas:

- 1) Label/File Functions Area - 1501
- 2) Status Area - 1502
- 3) Graphic Design Area - 1503
- 4) Create/Edit Options Area - 1504

Initially, the Label/ File Functions Area 1501 and the Status Area 1502 are active. The Label/File Function Area 1501 allows the user to perform general actions on the label configuration files. The Status Area 1502 is always active but there is no direct user interface with this area, since this area reports general error messages. When the Label/File Function Area 1501 is inactive, the Graphic Design Area 1503 and the Create/Edit Options Area 1504 are active. The Graphics Design Area 1503 is the graphical area where the block-wire diagram of the current label design is

-37-

presented. The Create/Edit Options Area 1504 is where the user selects the objects and their associated parameters used to build the label.

5 Since the Label/File Function Area 1501 is the only interactive area initially, the user must begin here. There are nine active functions in this area, of which five are "label" functions:

- 1) Create Label
- 2) Copy Label
- 10 3) Edit Label
- 4) View Label
- 5) Plot Label

The other four functions are:

- 6) Create Text
- 15 7) Select Template Size
- 8) Quit
- 9) Display Text File

Depending on which function is chosen, the application prompts the user for associated information. These functions and the required associated information are discussed in detail below.

1) Create Label - The "Create Text" and "Select Template Size" functions are directly associated with "Create Label" and these three functions are grouped together in a functional manner. The Create Label function must be preceded by both the Create Text function and the Select Template Size function in order to initiate the proper Create Label parameters.

30 a) Create Text - This function is intended for the user to create the desired text format of the data file for the current label design. When the Create Text function is selected, a filename pop-up is activated. The user inputs the desired name of the data file and then a template for the data format is displayed. The user then inputs the actual data desired for the present label configuration as well as the maximum string length for the desired format

-38-

(maximum string length defaults to the string length of the current text string).

5 b) Select Template Size - This function allows the user to either choose the desired label template size from a current table or add a previously undefined template size to the table and select it. This template is the initial building block for all label designs.

10 Once the Create Text and Select Template Size functions have been completed, a label may be created. When the Create Label function is chosen, the filename pop-up is activated and the user inputs the name of the label configuration file to be created. When this name is "entered", the Label
15 File Function Area 1501 is temporarily disabled (except the Display Text File function) while the Graphics Design Area 1503 is activated, showing a ruled wire image of the current template, and all of the options in the Create/Edit Options Area 1504
20 are activated (Figure 16).

 The Create/Edit Options Area 1504 is made up of 5 active functional areas:

- 25 1) Objects
 2) Actions
 3) Style
 4) Size
 5) Save / Don't Save Label

30 The Objects function allows the user to choose the object type to be placed on the label, solicits the necessary information for the object type, and enables that object to be placed in the Graphical Design Area 1503. The other four functions are used to either address the contents of the label

-39-

configuration file or define certain aspects of the current object.

	Actions	:	Add	-	select to add an entity to l a b e l configuration file
5					
			Delete	-	select to delete an entity to label configuration file
10					
			Repaint	-	repaint all entities in current label configuration file
15					

Style : Only applied to Anchor (Alpha-Numeric Color Hatch Region) entities and Year Band entities. User may choose any currently available style simply by "pointing to" and "clicking" on the desired style.

```

Size      : Only applies to Anchor (Alpha-
            Numeric Color Hatch Region)
            entities and Year Band
            entities. User may choose any
30         currently available size
            simply by "pointing to" and
            "clicking" on the desired
            size. The size actually
            described the height of the
35         selected Style.

```

```
Save Label      :      Save current label
                  configuration file.
```

```

40      Don't Save Label      :      Do not save current
                                     label configuration
                                     file.

```

Note: Anchor and Year Bands are dependent on both the Style and the Size parameters. Vertical Color Bands and Horizontal Color Bands use the current Style selected for color formatting. These functions derive their information from "Style Libraries", which are proprietary files describing

-40-

certain graphical aspects of these objects types.

The Object function has nine entity types available for election and which are illustrated in Figure 16. When an entity type is chosen, a pop-up window appears which solicits certain information pertaining to that entity type:

5	Anchor (1601)	- Digit Style (S or D)	: Single or Double character format.
10		String Number	: from text file format.
15		String Position	: position of character in String Number.
20	Barcode (1602)	- String Number	: from text file format.
25		Bar Length	: number of characters (starting at string position one of String Number) to barcode.
30	Character (1603)	- String Number	: from text file format.
35		String Position	: position of character in String Number.
40		Character Angle	: Orientation of character (0, 90, 180, 270).
45		Character Height	: Actual height of character in mils.

-41-

	Hard Code (1604) - String Information:	The actual " h a r d c o d e d " t e s t String to b e displayed on the label.
5		
10	String Orientation:	Orientati o n o f string (0, 90, 180, 270).
15	String Height :	A c t u a l height of text in mils.
20	Horizontal (1605) - Style Digit :	(0 - 9) Choose the color of t h e Horizontal Bar. The current Style has a color associated to each digit 0-9.
25		
30		
	Logo - Logo Filename :	the name of the f i l e containing the point descripti on of the desired Logo.
35		
40	Text String (1606) String Number :	from the text file format.
45	Text Orientation:	Orientati o n o f string (0, 90, 180, 270).
50	Text Height :	A c t u a l height of text in mils.

-42-

Vertical (1607) - Style Digit : (0 - 9)
Choose the
color of
t h e
5 Vertical
Bar. The
current
Style has
a color
10 associated
to each
digit 0-9.

Year Band (1608) - Year : Enter desired year.

Once all of the necessary information for an
15 entity is gathered, the user can place the entity
on the template in the Graphic Design Area 1503 at
the desired position simply by moving the cursor to
the desired coordinates and "clicking" the proper
mouse button. An entity may be deleted simply by
20 choosing the Delete Action and then pointing to the
desired entity to be deleted with the cursor and
"clicking".

2) Copy Label - The Copy Label function
allows a user to copy an existing label
25 configuration file in order to create a modified
version of that configuration. When selected, a
pop-up is activated which prompts the user for the
name of the source label configuration file (From:)
and the target label configuration file (To:).

30 3) Edit Label - The Edit Label function
allows a user to edit an existing label
configuration file. When selected, a filename pop-
up is activated and the user inputs the name of the
desired label configuration file. When "entered",
35 the configuration for that label appears in the
Graphics Design Area 1503. The Label/File Function
Area 1501 is temporarily disabled and the
Create/Edit Options Area 1504 is activated. From

-43-

here, the user has all of the options just as if the Create Label function was chosen.

4) View Label - The View Label function allows the user to view an existing label configuration file. When selected, a filename pop-up is activated and the user inputs the name of the desired label configuration file. When "entered", the configuration for the label appears in the Graphics Design Area 1503 but there is no user interaction (i.e. no functional change to active areas and editing is not allowed).

5) Plot Label - The Plot Label function allows the user to plot a hard copy of the desired label. When selected, a filename pop-up is activated and the user inputs the name of the desired label configuration file. When "entered", the phase two processor is invoked and the label is plotted, leaving the phase one application active during processing (i.e. user can continue to work on other labels while plotting).

6) Create Text - See Create Label above.

7) Select Template Size - See Create Label above.

8) Quit - The Quit function prompts the user for verification (Yes/No) and quits the application if "Yes" is chosen.

9) Display Text File - The Display Text File function, which is always active, allows the user to look at the current text format of the data file as well as the actual text being used. When selected, a filename pop-up is activated and the user inputs the name of the desired data file. When "entered", the actual file appears on the screen. This function is valuable in the respect that almost all Object types depend on some information from the data file.

-44-

Label and Template Merging

The labels defined by a user, as described above, are populated with indicia according to the operational steps of a label routine as illustrated for example in Figure 14. Again using the employee database example, at step 1401 the user activates the label routine by accessing the routine via user interface 114. The routine at step 1402 queries the user for input data, such as: employee name, social security number, date of birth, department number, pay grade, number and types of labels. At step 1403, indicia generator 112 automatically generates an ordered sequence of indicia, such as employee number, date of hire. Once the indicia are generated, the defined sequence of labels is created by combining at step 1404 the user input indicia and automatically generated indicia into each label in the subset of labels. The routine at step 1405 uses the input data that defines the number and types of labels to generate a template for each label. The templates include both fixed and variable template fields, which are typically defined by the user identifying existing label types that are stored in memory. This example notes three labels: payroll file, department file, medical file - illustrated in Figures 17 - 19, respectively. Thus, the payroll file label 1700 of Figure 17 notes employee name 1701, employee number 1702 and social security number 1703 in alphanumeric form, and in bar code form 1704 as well as year of hire in both alphanumeric 1705 and color code form 1706. In order to simplify file identification, a color band 1707 indicative of type of file can be included. The department file label 1800 of Figure 18 lists employee name 1801, and employee number 1802 in alphanumeric form and in bar code form 1805 while pay grade 1803 and year

-45-

of hire 1804 are illustrated by color codes on the label. Finally, Figure 19 represents the medical file label 1900 which again lists employee name 1901, employee number 1902 but also year of birth 1903 and department 1908 in alphanumeric form and in bar code form 1904 while year of birth 1905 and department 1906 are displayed in color code form and bar code form 1907. These labels are produced by combining at step 1406 the generated indicia, user input indicia and generated fixed and variable template fields. The resultant label data is transmitted at step 1407 to the printer apparatus 170* as described above.

Thus, a subset of labels, each a unique combination of indicia and templates, are automatically produced as part of a series of labels. Each subset is, in this example, keyed on a single data entry or event (new employee). It is obvious that various combinations and variations of this arrangement are possible. Bar codes, alphanumeric indicia, color codes, magnetic codes can be used as well as label formats whose configurations are only limited by the imagination of the user who creates the templates.

While a specific embodiment of this invention has been disclosed herein, it is expected that those skilled in the art can design other embodiments that differ from this particular embodiment but fall within the scope of the appended claims.

WE CLAIM:

1. Apparatus for automatically producing a series of labels, each label in said series of labels containing a combination of a set of indicia and variable template fields individual to said label and ordered according to a user-defined ordering, comprising:
- 5 means (111) for defining a label template having at least one writable indicia field and at least one variable template field;
- 10 means (112) for automatically generating a set of indicia for each of said labels in said series of labels, wherein each successive set of indicia in said series of labels is ordered according to a user defined ordering;
- 15 means (111) for automatically generating a set of data representative of said at least one variable template field for each label in said series of labels according to a predetermined label ordering; and
- 20 means (113), responsive to said indicia generating means (112) and said data generating means (111), for producing individually identified labels for each of said labels in said series of labels.

2. The apparatus of claim 1 further comprising:

- 5 means (103*-107*), responsive to said producing means (113) producing an individually identified label, for automatically printing said individually identified label on to label media (300).

-47-

3. The apparatus of claim 1 further comprising:

wherein said producing means (113) comprises means (113) for inserting each of said
5 sets of indicia and data, individual to each label in said series of labels, into said one or more indicia fields and said at least one variable template field respectively for each label in said series of labels; and
10 means (103*-107*) for automatically printing each of said individually identified labels in said series of labels on to label media (300).

4. The apparatus of claim 3 further comprising:

means (204, 207, 209, 211) responsive to said inserting means (113) for converting said label template data and said inserted indicia into printing control signals defining individually identified labels.

5. The apparatus of claim 4 further comprising:

means (1407) for transmitting said printing control signals to said automatically
5 printing means (103*-107*).

6. The apparatus of claim 5 wherein said automatically printing means (103*-107*) comprises:

computer controlled printing apparatus for converting said printing control signals to
5 printed indicia and template on said label media (300).

-48-

7. The apparatus of claim 1 wherein said defining means (111) comprises:

means (204) for delimiting boundaries of said indicia fields.

8. The apparatus of claim 7 wherein said defining means (111) further comprises:

means (204) for generating label media registration marks (r).

9. The apparatus of claim 1 wherein said indicia generating means (112) comprises:

5 means (205, 206, 208, 210) for replicating at least one indicia in each of said n sets of indicia to produce both a human readable and a corresponding machine readable indicia in each of said n sets of indicia.

10. The apparatus of claim 1 wherein said indicia generating means (112) comprises:

5 means (205, 206, 208, 210) for replicating at least one indicia in each of said n sets of indicia to produce two duplicate indicia in content but different in form.

11. The apparatus of claim 1 further comprising:

means (220) for dividing said label media (300) into individual labels.

12. The apparatus of claim 1 wherein said indicia generating means (112) comprises:

5 means (1403) for automatically generating n sets of indicia, wherein each set of indicia is ordered according to a user-defined ordering, where n is a positive integer at least equal to 1.

-49-

13. The apparatus of claim 12 wherein said data generating means (111) comprises:

means (1405) for storing m sets of data, each of said m sets of data defining a label
5 template having at least one writable indicia field, where m is a positive integer greater than 1.

14. The apparatus of claim 13 wherein said producing means (113) comprises:

means (1406), responsive to said generating means (112) and said m sets of stored
5 data, for producing m individually identified labels for each of said n sets of indicia received from said generating means (112).

15. The apparatus of claim 14 wherein said producing means (113) comprises:

means (1404) for excerpting, for each of said m sets of stored data, a plurality of indicia
5 from each of said n sets of indicia.

16. The apparatus of claim 15 wherein said producing means (113) further comprises:

means (1404) for combining said excerpted indicia and a corresponding one of said m sets of
5 stored data to produce an individually identified label.

17. The apparatus of claim 1 wherein said defining means (111) comprises:

means (201-203) for defining a sheet template consisting of a matrix of n*m label
5 templates, each containing at least one writable indicia field and at least one variable template field.

-50-

18. The apparatus of claim 17 wherein said generating means (112) comprises:

5 means (205-212) for generating $n*m$ sets of indicia, each of said sets of indicia corresponding to both human readable and machine readable entries in said indicia fields on one of said labels in said series, according to a predetermined label identification ordering to individually identify each label.

19. The apparatus of claim 17 wherein said generating means (112) comprises:

5 means (205-212) for generating $n*m$ sets of indicia, each of said sets of indicia corresponding to entries in said indicia fields on one of said labels in said series where said entries consist of two duplicate indicia in content but different in form, according to a predetermined label identification ordering to individually
10 identify each label.

20. The apparatus of claim 17 wherein said generating means (112) comprises:

5 means (205-212) for generating $k* (n*m)$ sets of indicia, each of said sets of indicia corresponding to entries in said indicia fields on one of said labels in said series, according to a predetermined label identification ordering to individually identify each label.

21. The apparatus of claim 1 wherein said defining means (111) comprises:

5 means (213-220) for defining a label set template comprising an $n*m$ pattern of individual label templates, each of which includes k writable information fields and at least one variable template field.

-51-

22. The apparatus of claim 21 wherein said indicia generating means (112) comprises:

means (205-212) for generating an ordered sequence of $n \times m$ indicia, each of said $n \times m$ indicia consisting of k characters.

23. The apparatus of claim 22 wherein said producing means (113) comprises:

means (1404) for inserting the k characters of each successive one of said $n \times m$ indicia in the corresponding writable information fields of successive individual label templates.

24. The apparatus of claim 1 wherein said generating means (112) comprises:

means (205-212) for generating $n \times m$ sets of indicia, each of said sets of indicia corresponding to both human readable and machine readable entries in said indicia fields on one of said labels in said series, according to a predetermined label identification ordering to individually identify each label.

25. The apparatus of claim 1 wherein said generating means (112) includes:

means (205-212) for generating $n \times m$ sets of indicia, each of said sets of indicia corresponding to entries in said indicia fields on one of said labels in said series where said entries consist of two duplicate indicia in content but different in form, according to a predetermined label identification ordering to individually identify each label.

-52-

26. A method of automatically producing a series of labels, each label containing indicia individual to said label, comprising the steps of:

5 defining a label template having at least one writable indicia field and at least one variable template field;

10 automatically generating indicia and data, representative of said at least one variable template field, individual to each label in said series of labels, according to the user defined ordering;

15 automatically producing, in responsive to said generated indicia and said generated data, individually identified labels for each of said labels in said series of labels.

27. The method of claim 26 further comprising the step of:

automatically printing said individually identified label on to label media.

28. The method of claim 26 wherein said step of producing comprises:

5 inserting each of said sets of indicia and data, individual to each label in said series of labels, into said one or more indicia fields and said at least one variable template field respectively for each label in said series of labels; and

10 automatically printing each of said individually identified labels in said series of labels on to label media.

-53-

29. The method of claim 26 wherein said step of defining comprises:

delimiting boundaries of said indicia fields.

30. The method of claim 26 wherein said step of defining further comprises:

generating label media registration marks.

31. The method of claim 30 wherein said step of generating comprises:

replicating at least one indicia in each of said n sets of indicia to produce both a human readable and a corresponding machine readable indicia in each of said n sets of indicia.

32. The method of claim 30 wherein said step of generating comprises:

replicating at least one indicia in each of said n sets of indicia to produce two duplicate indicia in content but different in form.

33. The method of claim 30 further comprising the step of:

converting said label template data and inserted indicia into printing control signals defining individually identified labels.

34. The method of claim 33 further comprising the step of:

transmitting said printing control signals to a printing apparatus.

-54-

35. The method of claim 34 wherein said step of printing comprises:

5 converting, in a computer controlled printing apparatus, said printing control signals to printed indicia and template on said label media.

36. The method of claim 30 further comprising the step of:

dividing said label media into individual labels.

37. The method of claim 26 wherein said step of indicia generating comprises:

5 automatically generating n sets of indicia, wherein each set of indicia is ordered according to a user-defined ordering, where n is a positive integer at least equal to 1.

38. The method of claim 37 wherein said step of data generating comprises:

5 storing m sets of data, each of said m sets of data defining a label template having at least one writable indicia field, where m is a positive integer greater than 1.

39. The method of claim 38 wherein said step of producing comprises:

5 producing, in response to said step of generating and said m sets of stored data, m individually identified labels for each of said n sets of indicia.

-55-

40. The method of claim 26 wherein said step of producing comprises:

5 excerpting, for each of said m sets of stored data, a plurality of indicia from each of said n sets of indicia.

41. The method of claim 40 wherein said step of producing further comprises:

5 combining said excerpted indicia and a corresponding one of said m sets of stored data to produce an individually identified label.

42. The method of claim 26, wherein said step of defining comprises:

5 defining a sheet template consisting of a matrix of $n \times m$ label templates, each containing at least one writable indicia field and at least one variable template field.

43. The method of claim 42 wherein said step of generating includes:

5 generating $n \times m$ sets of indicia, each of said sets of indicia corresponding to both human readable and machine readable entries in said indicia fields on one of said labels in said series, according to a predetermined label identification ordering to individually identify each label.

44. The method of claim 26 wherein said step of generating includes:

5 generating $n \times m$ sets of indicia, each of said sets of indicia corresponding to entries in said indicia fields on one of said labels in said series where said entries consist of two duplicate indicia in content but different in form, according

-56-

to a predetermined label identification ordering to individually identify each label.

45. The method of claim 26 wherein said step of generating includes:

5 generating $k * (n * m)$ sets of indicia, each of said sets of indicia corresponding to entries in said indicia fields on one of said labels in said series, according to a predetermined label identification ordering to individually identify each label.

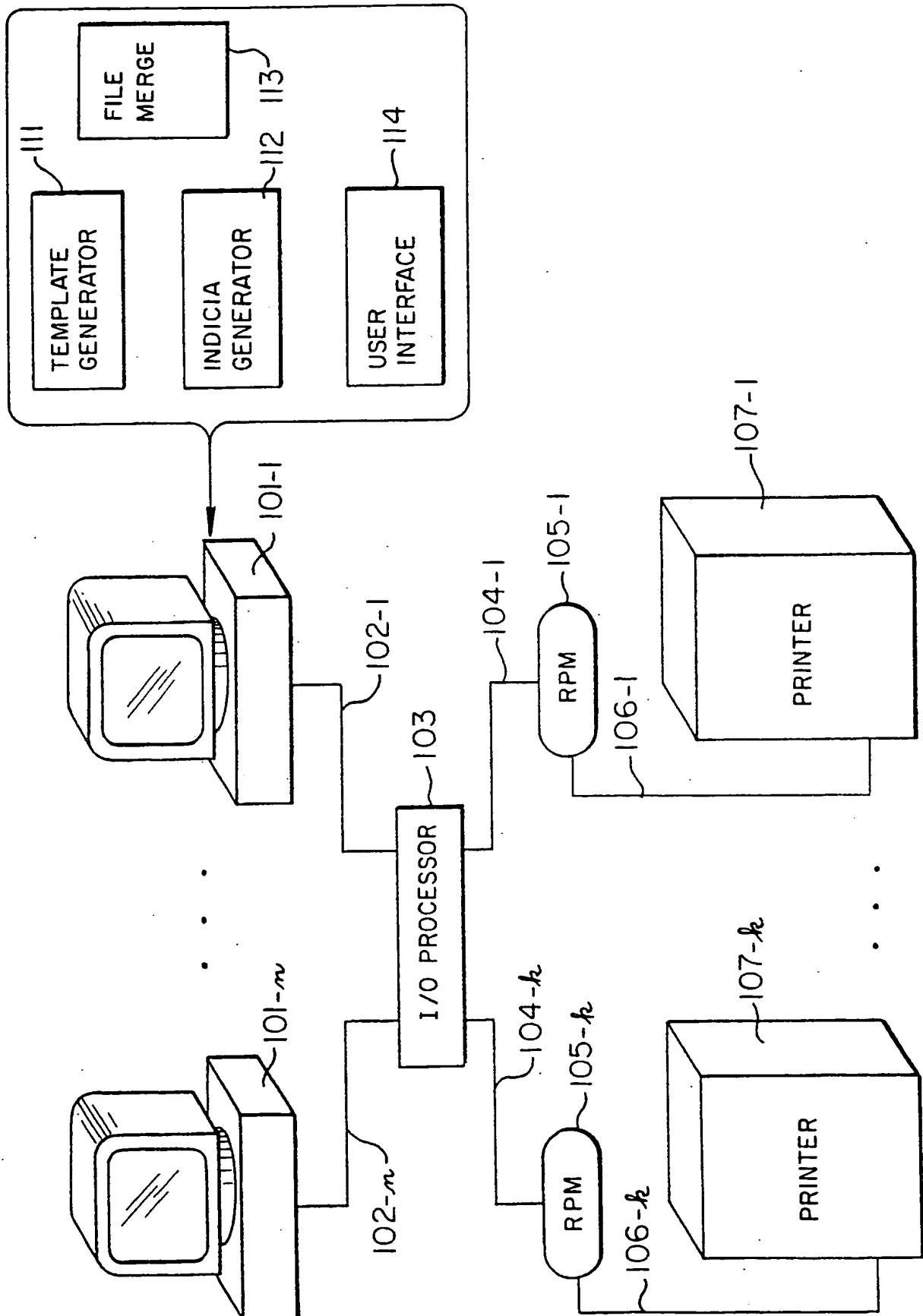


FIG. 1.

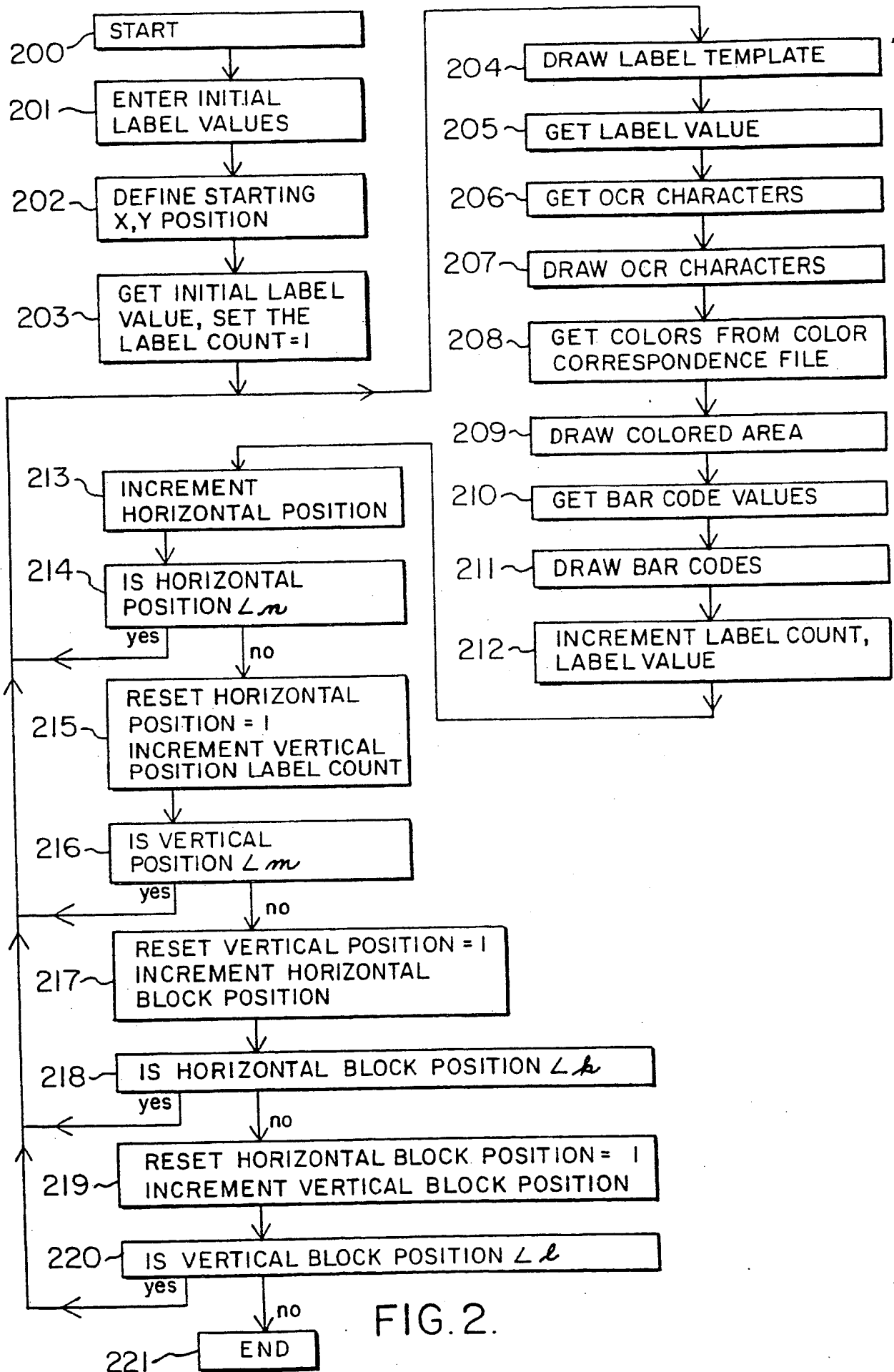


FIG. 2.

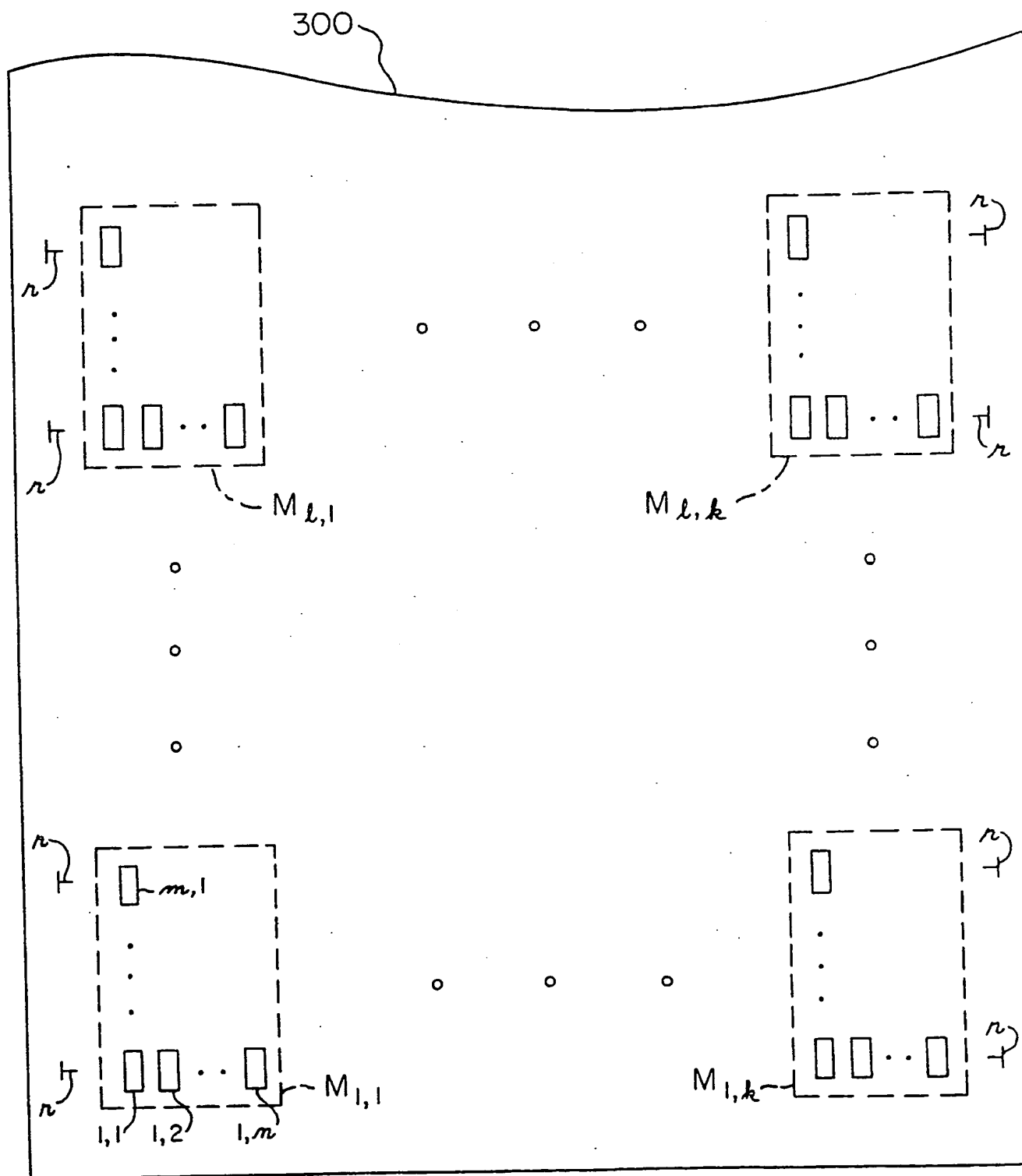


FIG. 3.

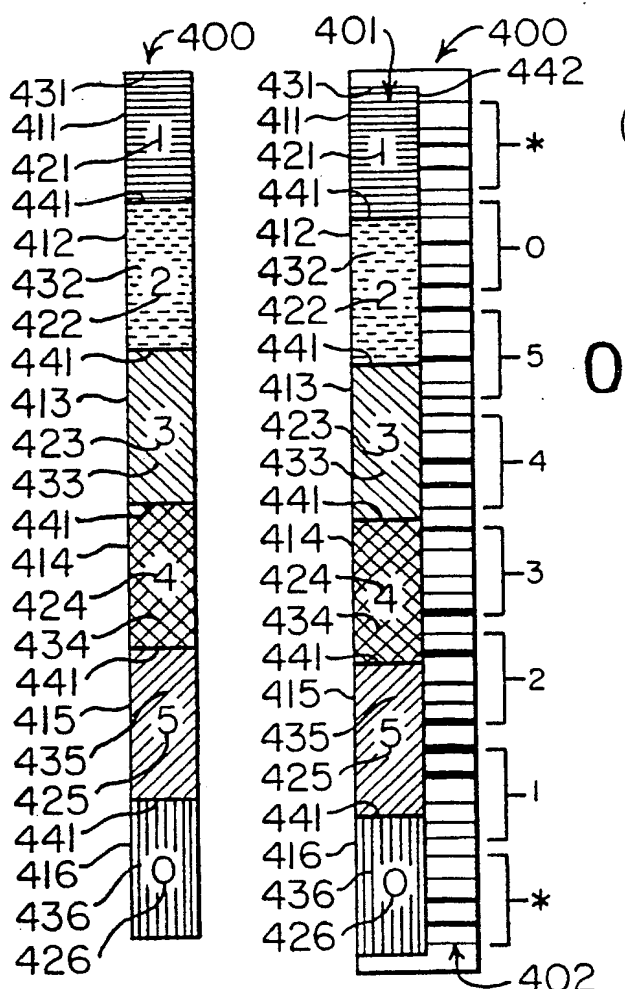


FIG. 4.

FIG. 5.



FIG. 6.



FIG. 7.

الندوة الأولى



FIG. 8.

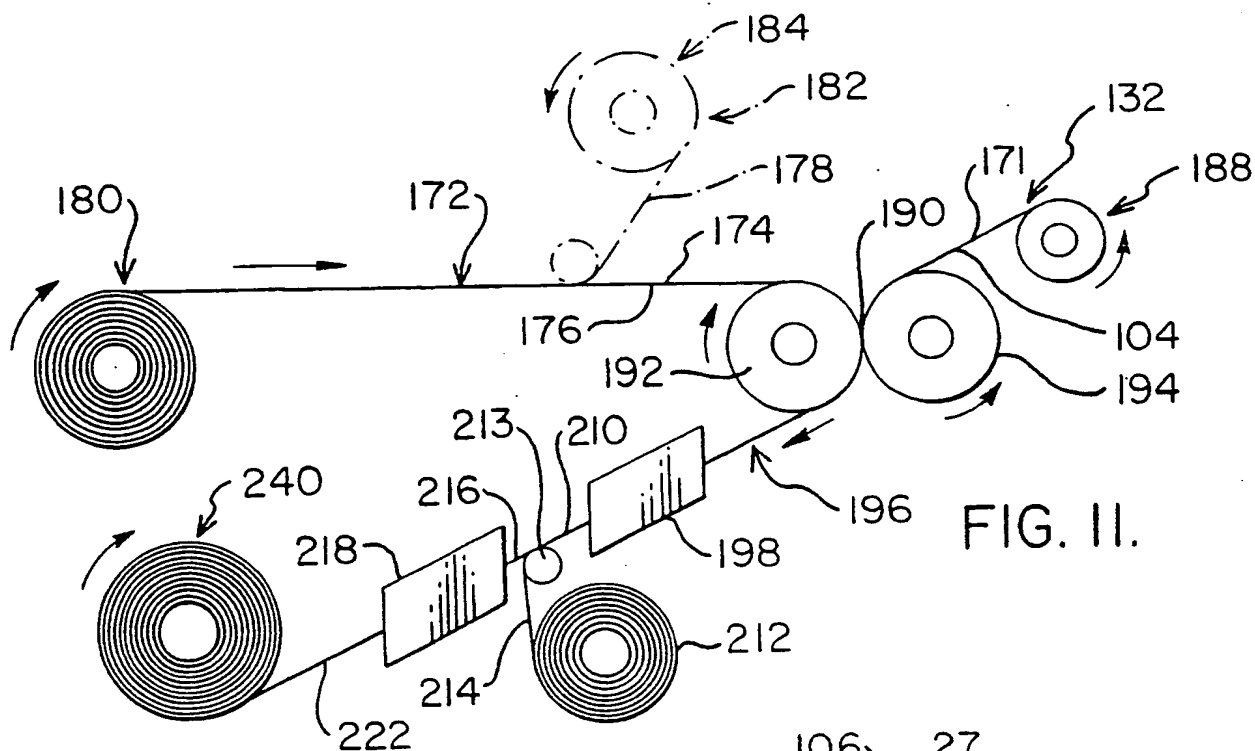


FIG. II.

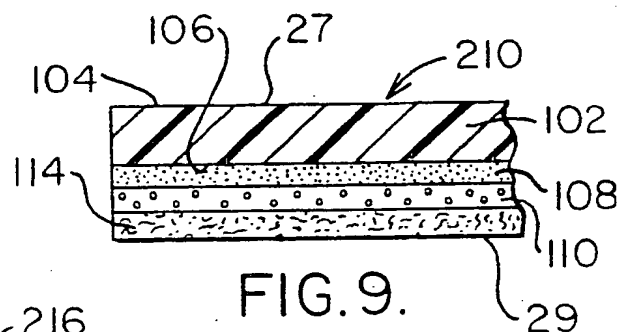


FIG. 9.

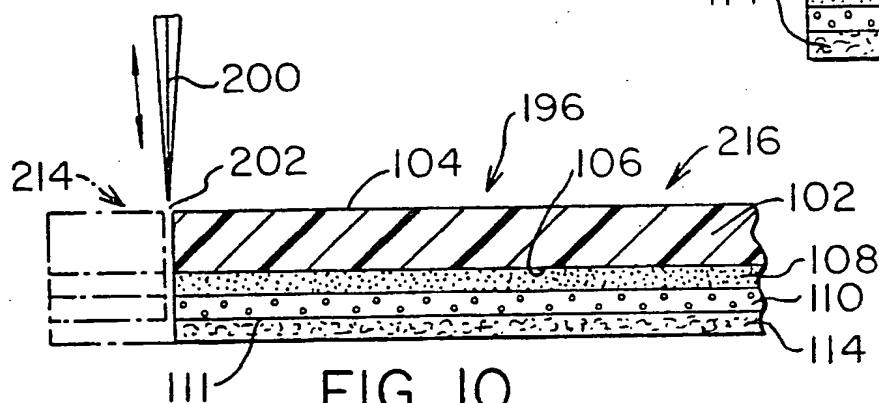


FIG. 10.

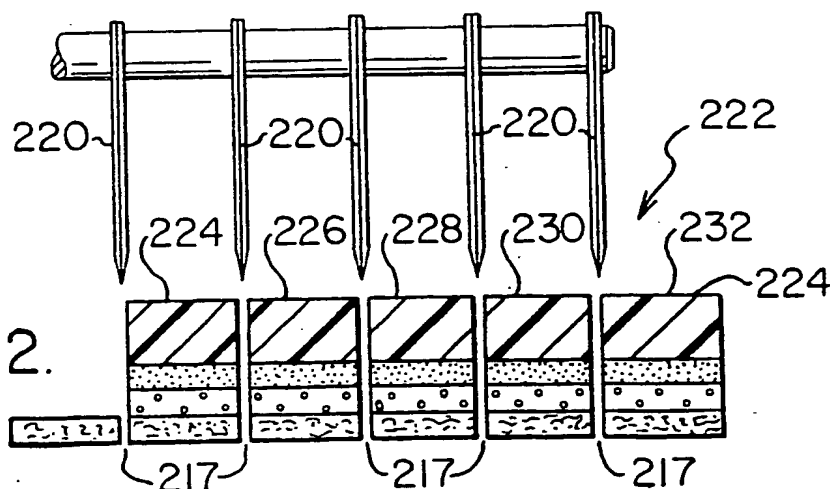
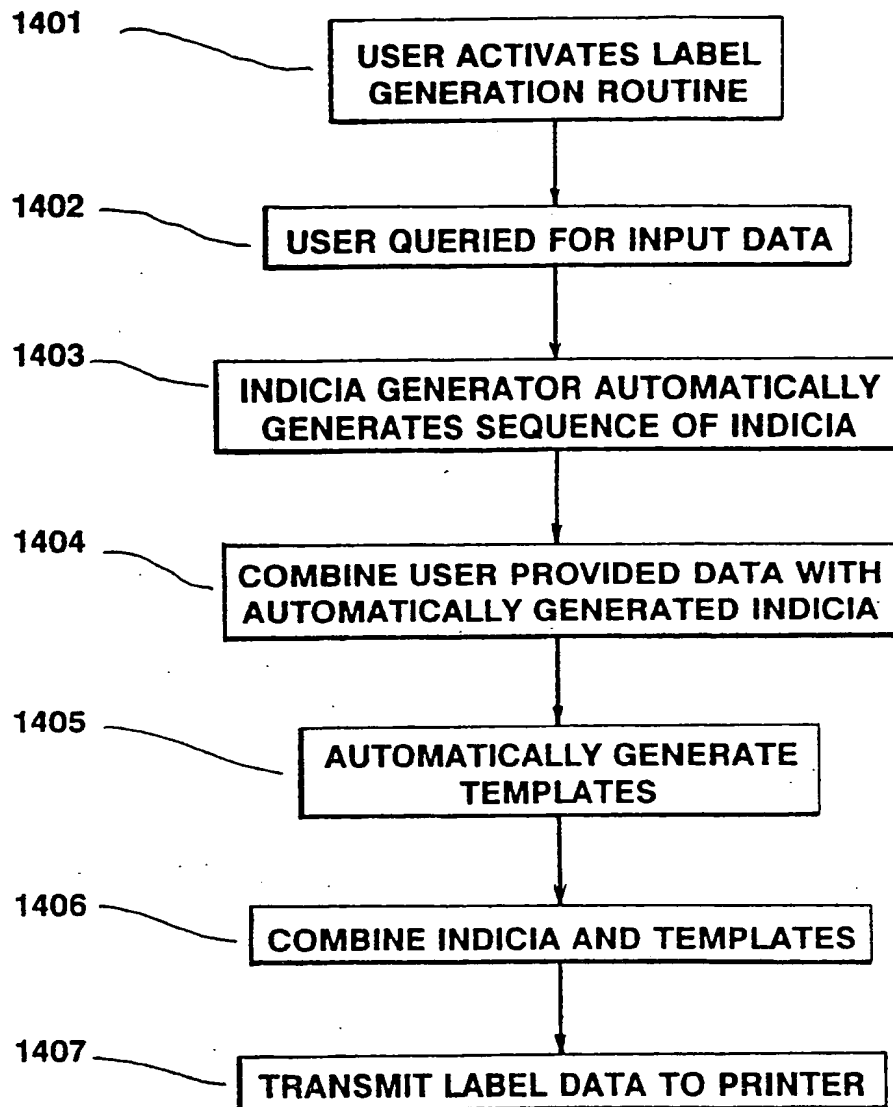


FIG. 12.

SOCIAL SECURITY #	ID #	DATE OF BIRTH	PAY GRADE	DATE OF HIRE	SHIFT	DEPT.	NAME
*	*	*	*	*	*	*	*
173214193	0791	01-22-44	GS2	12-20-90	1	12	MCINTOSH, JOHN J.
024673278	0792	06-03-22	GS7	12-20-90	1	04	TRUJILLO, JOSE A.
103555941	0793	11-11-56	GS5	12-20-90	3	03	CARR, MARY E.
*	*	*	*	*	*	*	*

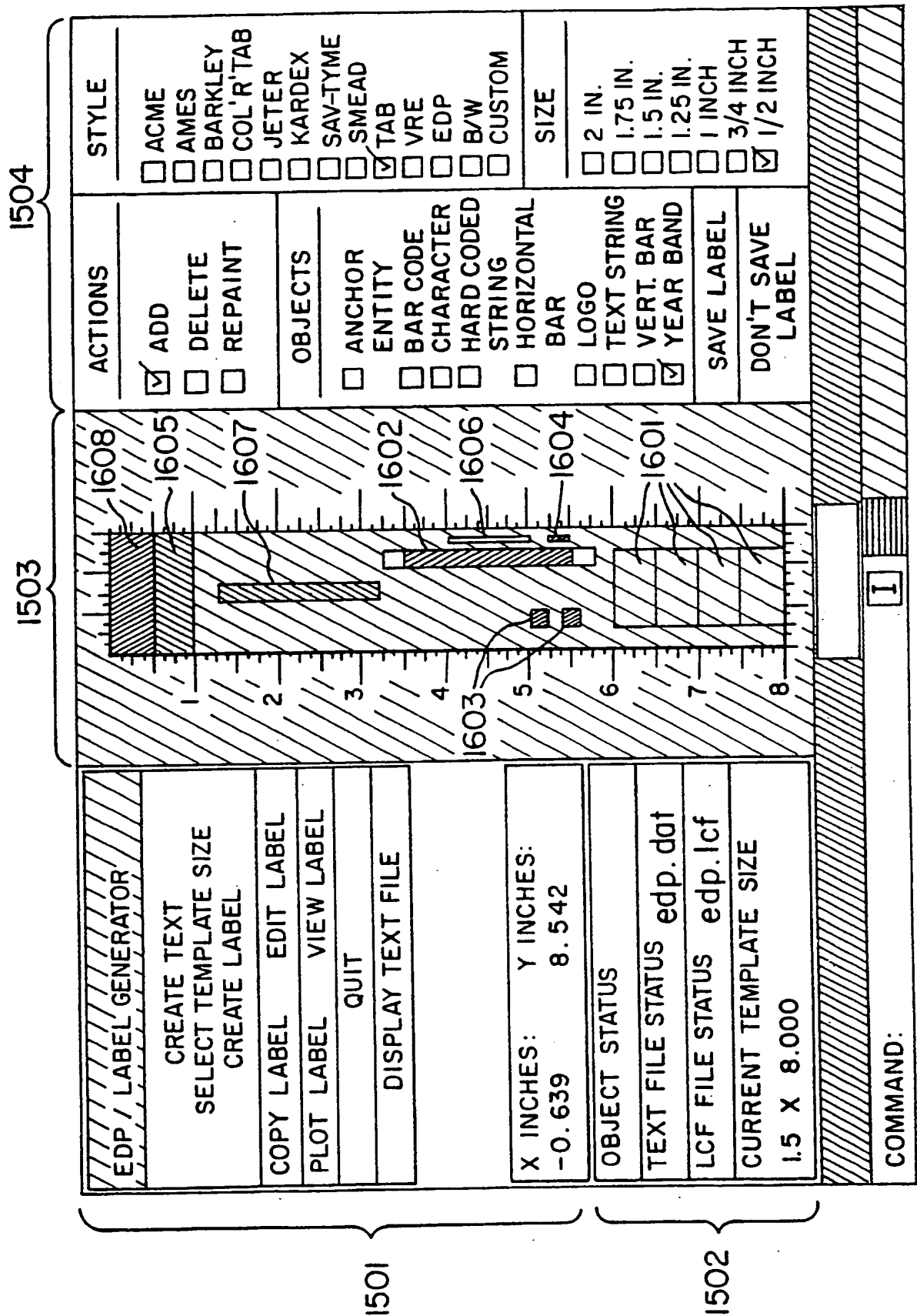
FIGURE 13

7 / 10

**FIGURE 14**

<div style="display: flex; justify-content: space-between;"> 1501 1502 </div> <div style="display: flex;"> <div style="flex: 1;"> <div style="border: 1px solid black; padding: 2px;">EDP LABEL GENERATOR</div> <div style="border: 1px solid black; padding: 2px;">CREATE TEXT SELECT TEMPLATE SIZE CREATE LABEL</div> <div style="border: 1px solid black; padding: 2px;">COPY LABEL EDIT LABEL PLOT LABEL VIEW LABEL QUIT</div> <div style="border: 1px solid black; padding: 2px;">DISPLAY TEXT FILE</div> <div style="border: 1px solid black; padding: 2px;">X INCHES: Y INCHES: 0.000 0.000</div> <div style="border: 1px solid black; padding: 2px;">OBJECT STATUS</div> <div style="border: 1px solid black; padding: 2px;">TEXT FILE STATUS</div> <div style="border: 1px solid black; padding: 2px;">LCF FILE STATUS</div> <div style="border: 1px solid black; padding: 2px;">CURRENT TEMPLATE SIZE</div> </div> <div style="flex: 1; background-color: #f0f0f0; padding: 2px;">COMMAND :</div> </div>		<div style="display: flex; justify-content: space-between;"> 1503 1504 </div> <div style="background-color: #f0f0f0; height: 100px;"></div>		<div style="display: flex; justify-content: space-between;"> <div> ACTIONS <input checked="" type="checkbox"/> ADD <input type="checkbox"/> DELETE <input type="checkbox"/> REPAINT </div> <div> OBJECTS <input type="checkbox"/> ANCHOR ENTITY <input type="checkbox"/> BAR CODE <input type="checkbox"/> CHARACTER <input type="checkbox"/> HARD CODED STRING <input type="checkbox"/> HORIZONTAL BAR <input type="checkbox"/> LOGO <input checked="" type="checkbox"/> TEXT STRING <input type="checkbox"/> VERT. BAR <input type="checkbox"/> YEAR BAND </div> <div> SAVE LABEL <input type="checkbox"/> DON'T SAVE LABEL </div> </div>		STYLE <input type="checkbox"/> ACME <input type="checkbox"/> AMES <input type="checkbox"/> BARKLEY <input type="checkbox"/> COL'R'TAB <input type="checkbox"/> JETER <input type="checkbox"/> KARDEX <input type="checkbox"/> SAV-TYME <input type="checkbox"/> SMEAD <input type="checkbox"/> TAB <input type="checkbox"/> VRE <input checked="" type="checkbox"/> EDP <input type="checkbox"/> B/W <input type="checkbox"/> CUSTOM SIZE <input type="checkbox"/> 2 IN. <input type="checkbox"/> 1.75 IN. <input type="checkbox"/> 1.5 IN. <input type="checkbox"/> 1.25 IN. <input checked="" type="checkbox"/> 1 INCH <input type="checkbox"/> 3/4 INCH <input type="checkbox"/> 1/2 INCH	
				<div style="border: 1px solid black; padding: 2px; text-align: center;">I</div>			

FIG. 15.



10 / 10

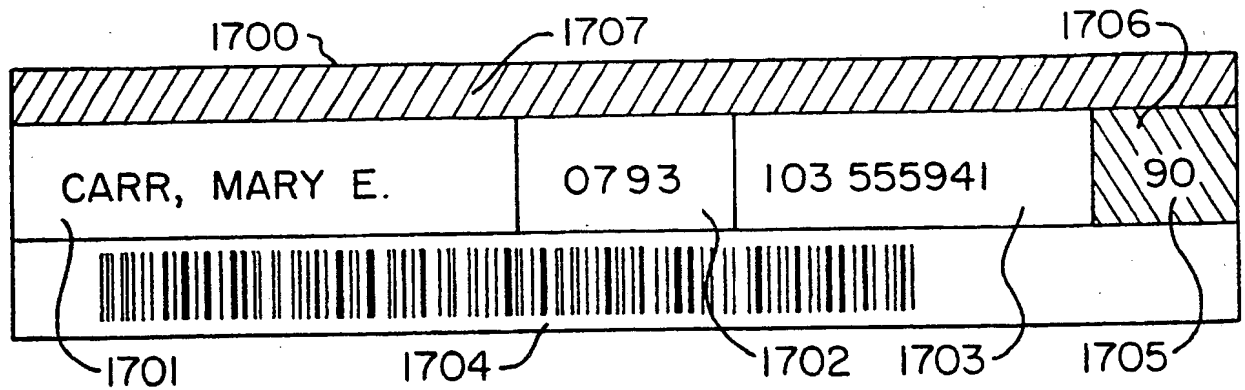


FIG. 17.

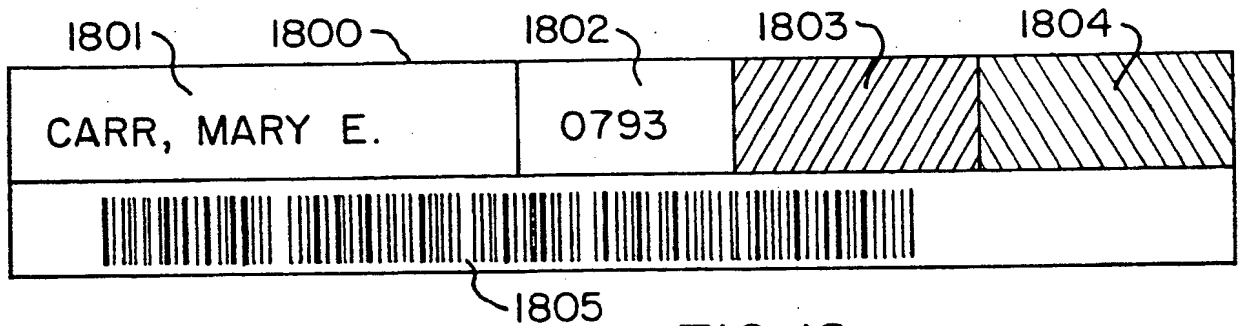


FIG. 18.

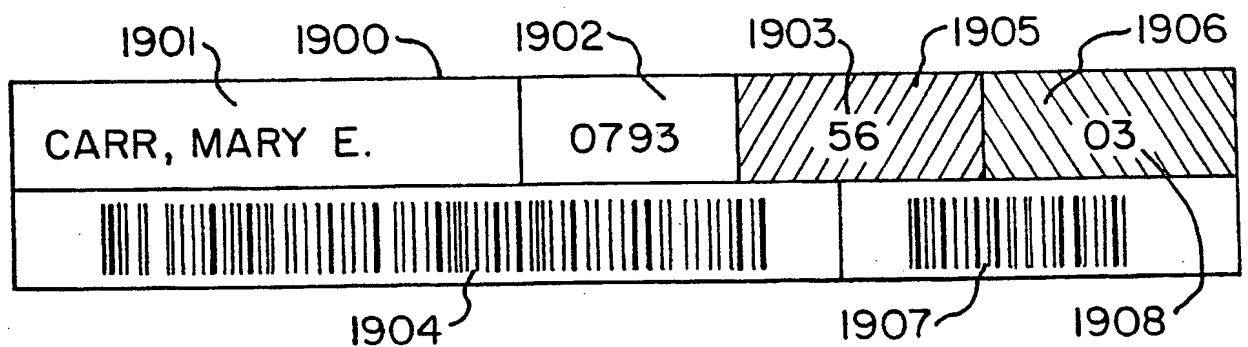


FIG. 19.

INTERNATIONAL SEARCH REPORT

PCT/US 92/10025

International Application No

I. CLASSIFICATION OF SUBJECT MATTER (If several classification symbols apply, indicate all)⁶

According to International Patent Classification (IPC) or to both National Classification and IPC
 Int.Cl. 5 G06K1/12; G06K19/08

II. FIELDS SEARCHEDMinimum Documentation Searched⁷

Classification System	Classification Symbols
Int.Cl. 5	G06K

Documentation Searched other than Minimum Documentation
 to the Extent that such Documents are Included in the Fields Searched⁸

III. DOCUMENTS CONSIDERED TO BE RELEVANT⁹

Category ¹⁰	Citation of Document, ¹¹ with indication, where appropriate, of the relevant passages ¹²	Relevant to Claim No. ¹³
X	WO,A,8 910 601 (ENGINEERED DATA PRODUCTS, INC.) 2 November 1989 see the whole document	1-45
A	IBM TECHNICAL DISCLOSURE BULLETIN vol. 33, no. 8, January 1991, ARMONK, NY, USA pages 230 - 236 'Method for automatically printing variable content labels on-line'	1,26

¹⁰ Special categories of cited documents:

- "A" document defining the general state of the art which is not considered to be of particular relevance
- "E" earlier document but published on or after the international filing date
- "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)
- "O" document referring to an oral disclosure, use, exhibition or other means
- "P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"A" document member of the same patent family

IV. CERTIFICATION

Date of the Actual Completion of the International Search

03 MARCH 1993

Date of Mailing of this International Search Report

24. 03. 93

International Searching Authority

EUROPEAN PATENT OFFICE

Signature of Authorized Officer

LASSON C.Y.M.

ANNEX TO THE INTERNATIONAL SEARCH REPORT ON INTERNATIONAL PATENT APPLICATION NO.

US 9210025
SA 67900

This annex lists the patent family members relating to the patent documents cited in the above-mentioned international search report.
The members are as contained in the European Patent Office EDP file on
The European Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

03/03/93

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
WO-A-8910601	02-11-89	US-A- 4939674	03-07-90
		AU-B- 631124	19-11-92
		AU-A- 3545289	24-11-89
		EP-A- 0411044	06-02-91
		JP-T- 3505268	14-11-91

FORM P0379